



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 171675



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/10/18	0.00	0.00	Start Up Large Fab-4		SL
110	Large Fab	1 pcs		2/10/18	0.00	1.00	Large Fab 2		SL
120	QC	1 pcs		2/10/18	0.00	0.00	QC9		PD 18-02-09
130	QC	1 pcs		2/10/18	0.00	0.00	QC5		PD 18-02-09
140	HandFinish	1 pcs		2/10/18	0.00	0.19	HandFinish1		18-02-12
150	QC	1 pcs		2/10/18	0.00	0.00	QC7-2		CPL
180	Large Fab	1 pcs		2/10/18	0.00	1.00	Large Fab 2		CPL
190	QC	1 pcs		2/10/18	0.00	0.00	QC10		CPL
200	QC	1 pcs		2/10/18	0.00	0.00	QC5		CPL
210	HandFinish	1 pcs		2/10/18	0.00	0.19	HandFinish1		SL 2018/02/18
220	Powdercoat	1 pcs		2/10/18	0.00	0.30	Powdercoat1		BR 18-2-21
230	HandFinish	1 pcs		2/12/18	0.00	0.19	HandFinish3		BEDVE-02-21
240	QC	1 pcs		2/12/18	0.00	0.00	QC3		38
250	Packaging	1 pcs		2/12/18	0.00	0.00	Packaging1-3		SP 2-22-2018
260	QC	1 pcs		2/12/18	0.00	0.00	QC4		
265	DC	1 pcs		2/12/18	0.00	0.00	DC		
270	Packaging	1 pcs		2/12/18	0.00	0.00	Packaging3-1		KG 022
280	QC21-FG	1 Ea		2/12/18	0.00	0.00	QC21		21 FEB 23 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 9:20 OVEN TEMPERATURE: 320° FINISH TIME: 9:50

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

wing walk. M138761

001083

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	1 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5040086
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5036202
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	5034373
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5034396
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400	Abrasion Strip 4" Wide (Per Foot)	1,200 Ea (1.2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	1	91	0
	D3219-1	2	98	0
	D3272-1	1	10	0
180-Large Fab	D3065-041	1	2	0
	D3066-1	2	90	0
	D3067-1	1	91	0
	MS20600-AD4W4	16	1,321	0
250-Packaging	AN3-35A	2	164	0
	AN4-13A	8	618	0
	AN5-36A	2	90	0
	D2230-3	4	133	0
	D2618	2	36	0
	D2856-400	1	95	0
	D3235-1	2	6	0
	D3278-041	1	21	0
	MS21042L3	2	3,805	0
	MS21042L4	8	1,991	0
	MS21042L5	2	501	0
	NAS1149D0363J	4	3,717	0
	NAS1149D0463J	16	3,420	0
	NAS1149D0563J	4	1,501	0

Part Specifications				
Specifications could not be found.				

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐														
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com  Heli - Access - Step RH - High Gear, Long Step, Aerazur Float Compatible PART NO: D350-591-312 Original Serial #: S040305 Revision: Operation: Start up Operation 02/07/18 Change No: CHG002		QTY Effective : _____ Disposition 																															
		MRB (QSI042) Appro _____ Completed By _____ Lead hand / Supervi _____ Approval Verificatio _____ QC / QA Coordinat _____ Approval _____																															
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Canada

Master Unit 001083

Tel (613) 632-5200

Containers on Master Unit 001083				
Serial No	Part No	Customer Part No	Status	Quantity
S044293	AN3-35A		Allocated	2
S044291	AN4-13A	AN4-13A	Allocated	8
S044290	AN5-36A	AN5-36A	Allocated	2
S044289	D2230-3	D2230-3	Allocated	4
S021820	D2618	D2618	Allocated	2
S044288	D2856-400-720	D2856-400-720	Allocated	2
S044285	D3278-041	D3278-041	Allocated	1
S044284	MS21042L3	MS21042L3	Allocated	2
S044282	MS21042L4	MS21042L4	Allocated	8
S044279	MS21042L5	MS21042L5	Allocated	2
S044278	NAS1149D0363J	NAS1149D0363J	Allocated	4
S044277	NAS1149D0463J	NAS1149D0463J	Allocated	16
S044276	NAS1149D0563J	NAS1149D0563J	Allocated	4

Qc 4 D3235-1 (x2) 5044958

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

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PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]